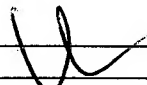
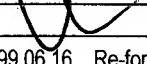


Date: Tuesday, 20/03/2007 8:59:26 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 31101	
Estimate Number : 10110	
P.O. Number : <i>N/A</i>	Part Number : D2012117
This Issue : 20/03/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2012-117 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 31325	Material : <i>N/A</i>
Written By : 	Due Date : 30/03/2007 Qty: 40 Um: Each
Checked & Approved By : 	
Comment : Est: C 99.06.16 Re-format, Now Laser Cut DM Est Rev:D Now on WaterJet 07-03-20 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.0144 sf(s)/Unit Total: 0.5754 sf(s)

304/316 .063 Sheet

Batch: *M101873**ml 07 03 26**(40)*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D2012

Dwg Rev: *C*Prog Rev: *C**ml 07 03 26**07/03/30**(40)*
(40)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

*ml 07 03 26**(40)***Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK*07-03-29*
*counted.**(40)*

5.0	BRAKE NC	NC BRAKE
-----	----------	----------

**Comment:** NC BRAKE

Form on press using DT8242 as per Dwg D2012-117

*ml 07/04/19**x40*

Date: Tuesday, 20/03/2007 8:59:26 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 31101

Part Number: D2012117

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-04-24 (40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 578

07/4/24 (40)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(40)
07-04-24

Job Completion



07-04-24

[illegible]

Job Number:

Seq. #:	Machine Or Operation:	Description :
1	1000	1000
2	1000	1000
3	1000	1000
4	1000	1000
5	1000	1000
6	1000	1000
7	1000	1000
8	1000	1000
9	1000	1000
10	1000	1000
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13	1000	1000
14	1000	1000
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95	1000	1000
96	1000	1000
97	1000	1000
98	1000	1000
99	1000	1000
100	1000	1000

1.0 PG PURCHASING

Comment: PURCHASING

Issue P/O:

E-mail or Ship DXF file to vendor

Laser cut flat pattern as per DXF File

Material release note is required.

2.0 D2012117F Clevis

Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)
CLEVIS

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0 QC6 DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 12:36:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 31101

Part Number: D2012117

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form on press using DT8242 as per Dwg D2012-117

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

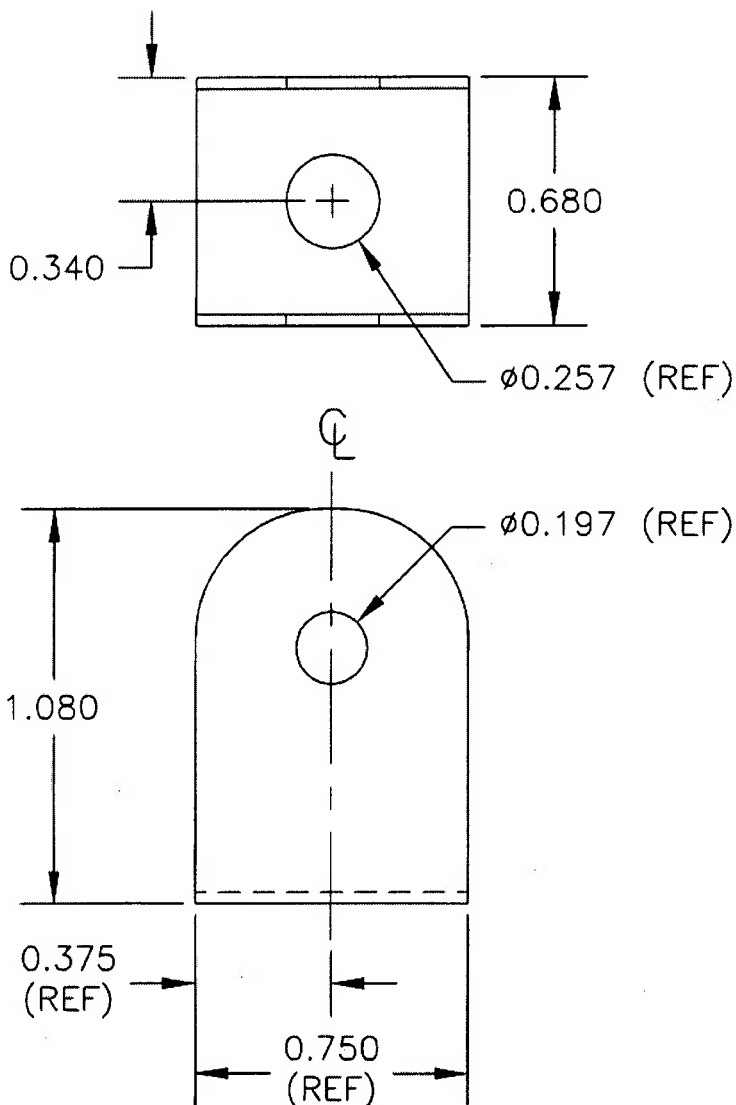
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RF	DRAWING NO. D2012-117	REV. C SHEET 1 OF 2
DATE 99.05.05	TITLE CLEVIS		SCALE 2:1
A	94.10.27	NEW ISSUE	
B	94.10.27	CHANGED HOLE SIZE, WAS D2012-107	
C	99.05.05	ADD FLAT PATTERN	

RELEASED
99.05.11 KE



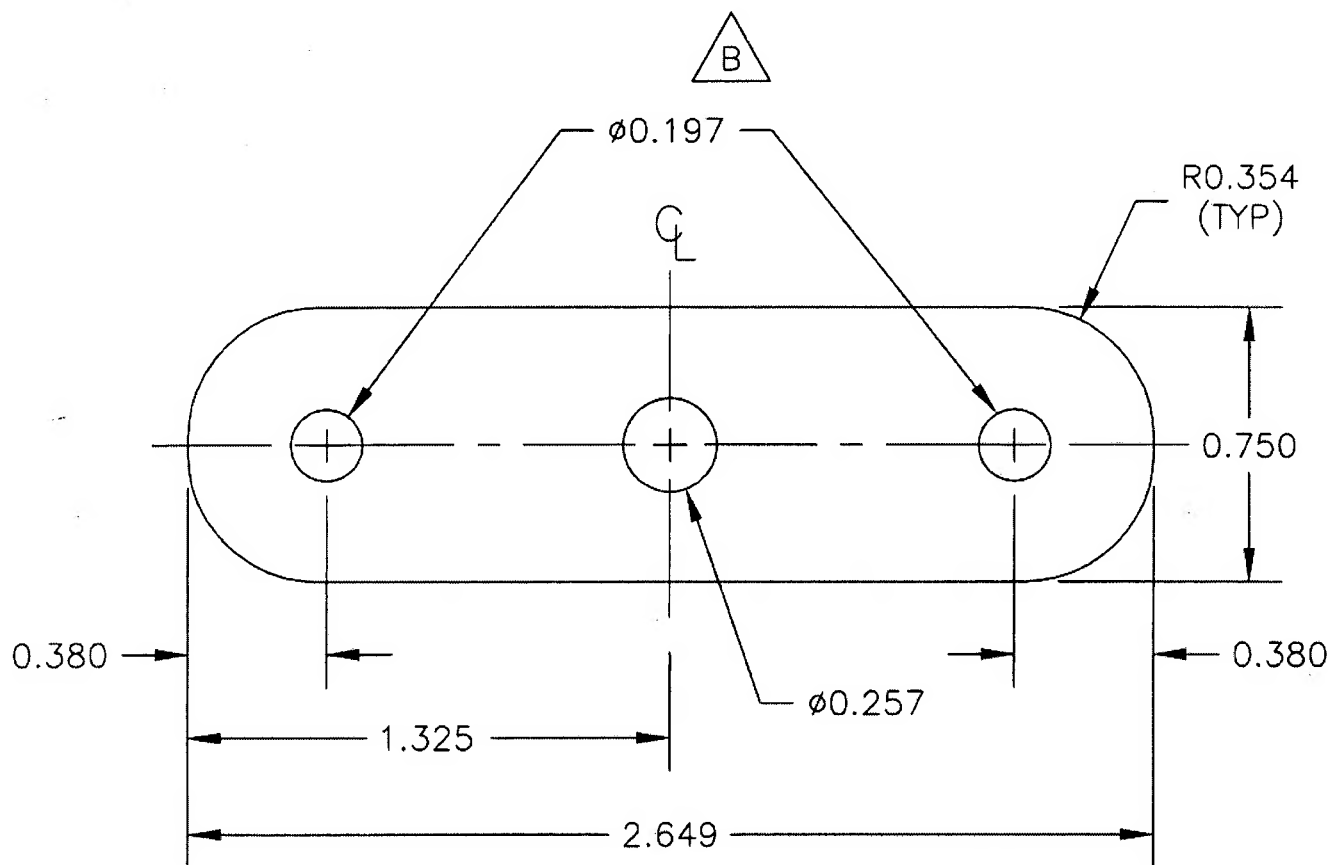
MATERIAL: AISI 304/316 SS 0.063 THICK
USE 0.032 BEND RADIUS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31101



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2012-117	REV. C SHEET 2 OF 2
DATE 99.05.05		TITLE CLEVIS	SCALE 2:1

RELEASED
99.05.11 KE



D2012-117 FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31101

MATERIAL: AISI 304/316 SS 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD		Work Order: 31101
Description: Clevis		Part Number: D2012-117
Inspection Dwg: D2012-117 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.197	+0.005-0.001	0.197	✓		VERN	
B 0.257	+0.006-0.001	0.260	✓		VERN	
C 1.325	+/- 0.010	1.320	✓		VERN	
D 0.380	+/- 0.010	0.374	✓		VERN	
E 0.380	+/- 0.010	0.375	✓		VERN	
F 0.750	+/- 0.010	0.755	✓		VERN	
G 2.649	+/- 0.010	2.641	✓		VERN	
H R0.354	+/- 0.010	R0.354	✓		Radius Gauge	
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: MM	Audited by: [Signature]	Prototype Approval:	N/A
Date: 070326	Date: 070329	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	